

As per End July

Work Order ID 71585



Wednesday, July 06, 2011 1:25:25 PM

Page 1

Item ID: D3407-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Tow Ring

Start Date: 7/6/2011 Start Qty: 8.00 *10*



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: *CL*

Date: 1107104 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3407	Rev E

100 0.00

Large Fab

Large Fab Memo 0.00

Large Fab Weld D3407-1/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004
A/R TIG174 ROD Batch: *M101972*

EL 11-8-17 X10

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC Memo 0.00

Quality Control

6/11-08-17

120 QC5- Inspect part completeness to step on W/O 0.00

QC Memo 0.00

Quality Control

S wlo817

-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71585

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Item ID: D3407-041

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Setup

Start



Revision ID:

Item Name: Tow Ring

Stop



Start Date: 7/6/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

130



Powdercoat

Powder Coating

140



QC

Quality Control

Memo

Mask Threaded Section

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10-10⁰⁰
 400°F
 10-40

QC3- Inspect Part Finish

0.00

10X SP 11-08-19

150



Packaging

Packaging

Identify as per dwg & Stock Location: H63

0.00

Memo

0.00

10 SP 11-08-22

10X SP 11-08-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71585

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Wednesday, July 06, 2011 1:25:25 PM

Item ID: D3407-041

Accept



Setup

Start



Revision ID:

Item Name: Tow Ring

Stop



Start Date: 7/6/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11/8/23 JH

Memo

0.00

MK
11-08-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, July 06, 2011 1:25:23 PM

Work Order ID: 71585



Parent Item: D3407-041



Parent Item Name: Tow Ring

Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A□05.10.14□New issue□KJ/EC

IPP Rev:B 08-09-09 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3407-1 		Manufactured	No			100	Each	12.0000	1	8		 Q 11-8-11	

Stem

72176 x10

Location

WA

Loc Qty

12

Loc Code

71017

D3407-5



Ring

Manufactured

Location

WA030

Loc Qty

3

Loc Code

69742

3

El 11-8-11.

72146 x10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

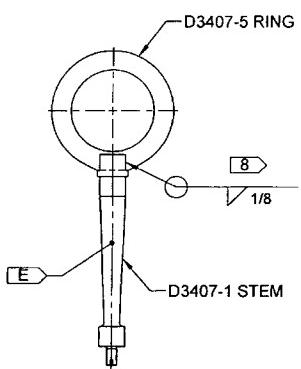
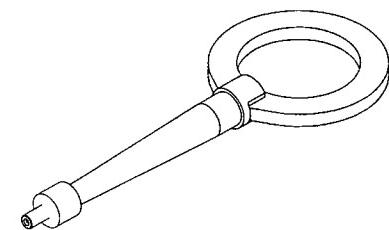
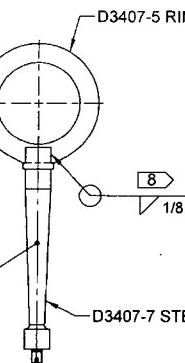
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

E

QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X	X		D3407-041	TOW RING
	X		D3407-043	TOW RING
	X		D3407-045	TOW RING
1			D3407-1	STEM
1	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

D3407-041 TOW RINGD3407-043 TOW RINGD3407-045 TOW RING ERELEASED
08-07-2005

A NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER E
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

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WITHOUT NOTICE
WORK ORDER
NO. 71585

CJ (1107/06)

E	ADD D3407-5 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>19</u>	DART AEROSPACE USA, INC.	
DRAWN	<u>10</u>	PORT HADLOCK, WA	
CHECKED	<u>1</u>	DRAWING NO.	REV. E
MFG. APPR.	<u>1</u>	D3407	SHEET 1 OF 5
APPROVED	<u>1</u>	TITLE	SCALE
DE APPR.	<u>1</u>	TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

A

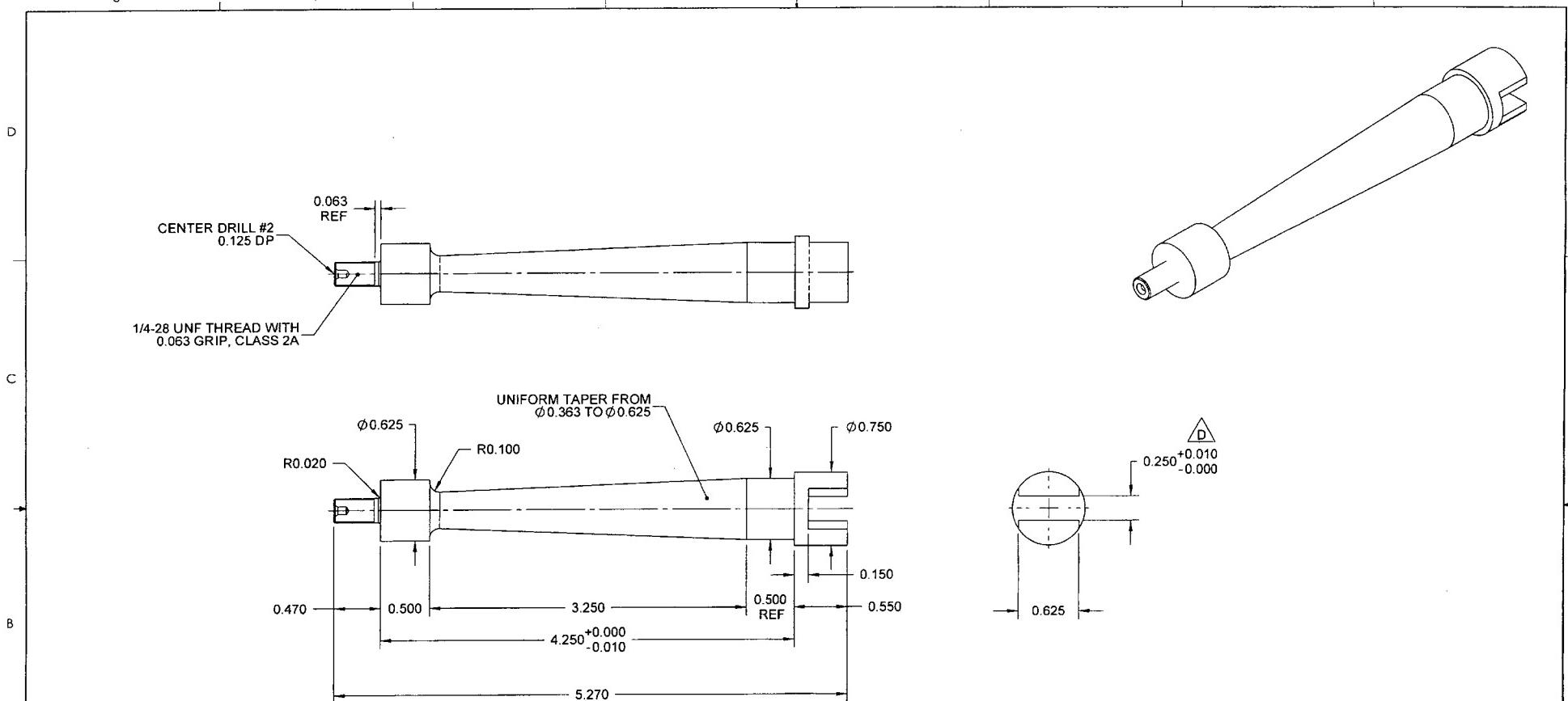
D

C

B

A

8 7 6 5 4 3 2 1

D3407-1 STEM

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WORK ORDER

NO. 11585

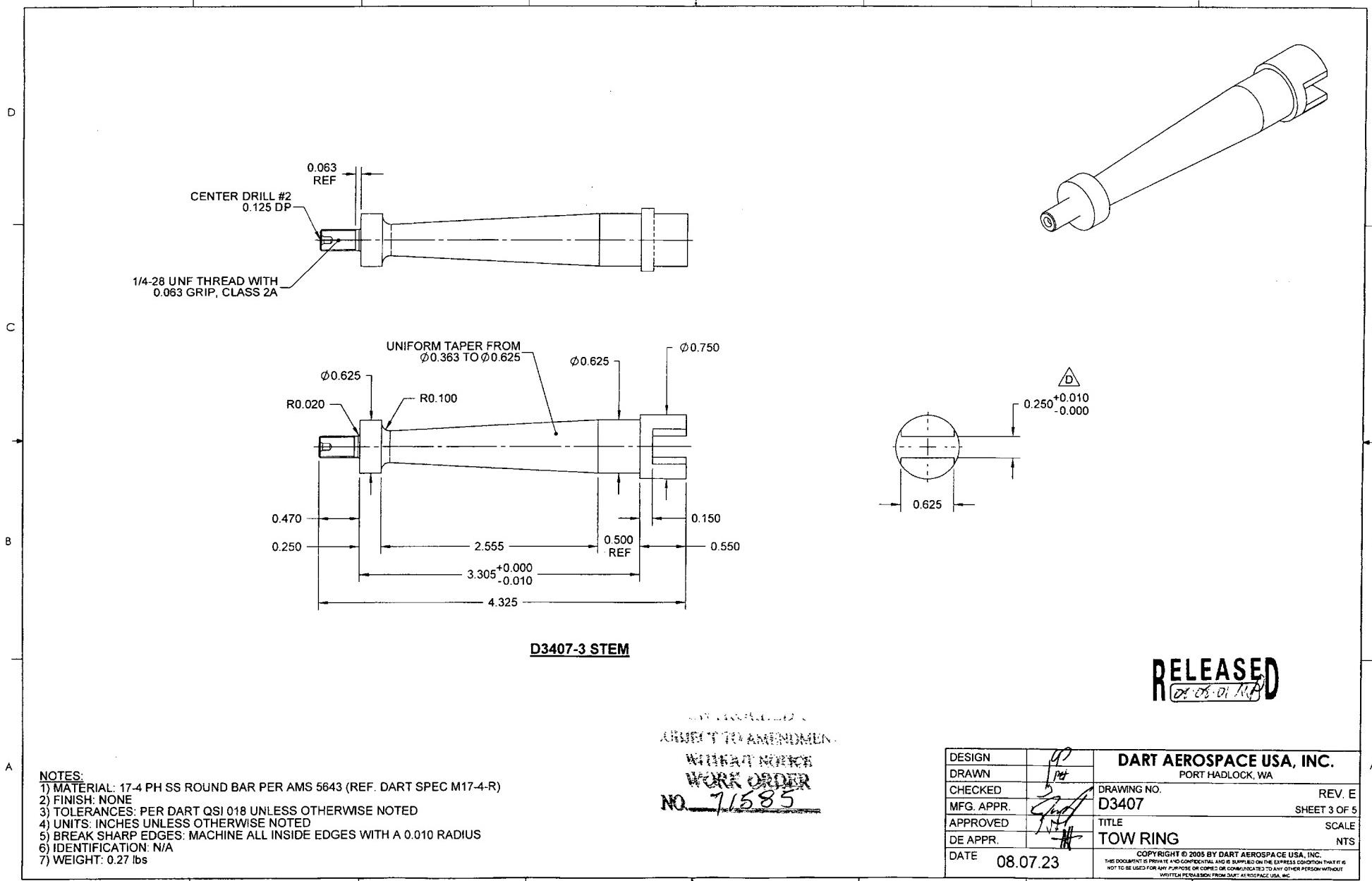
- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

RELEASED
06-05-01 JMW

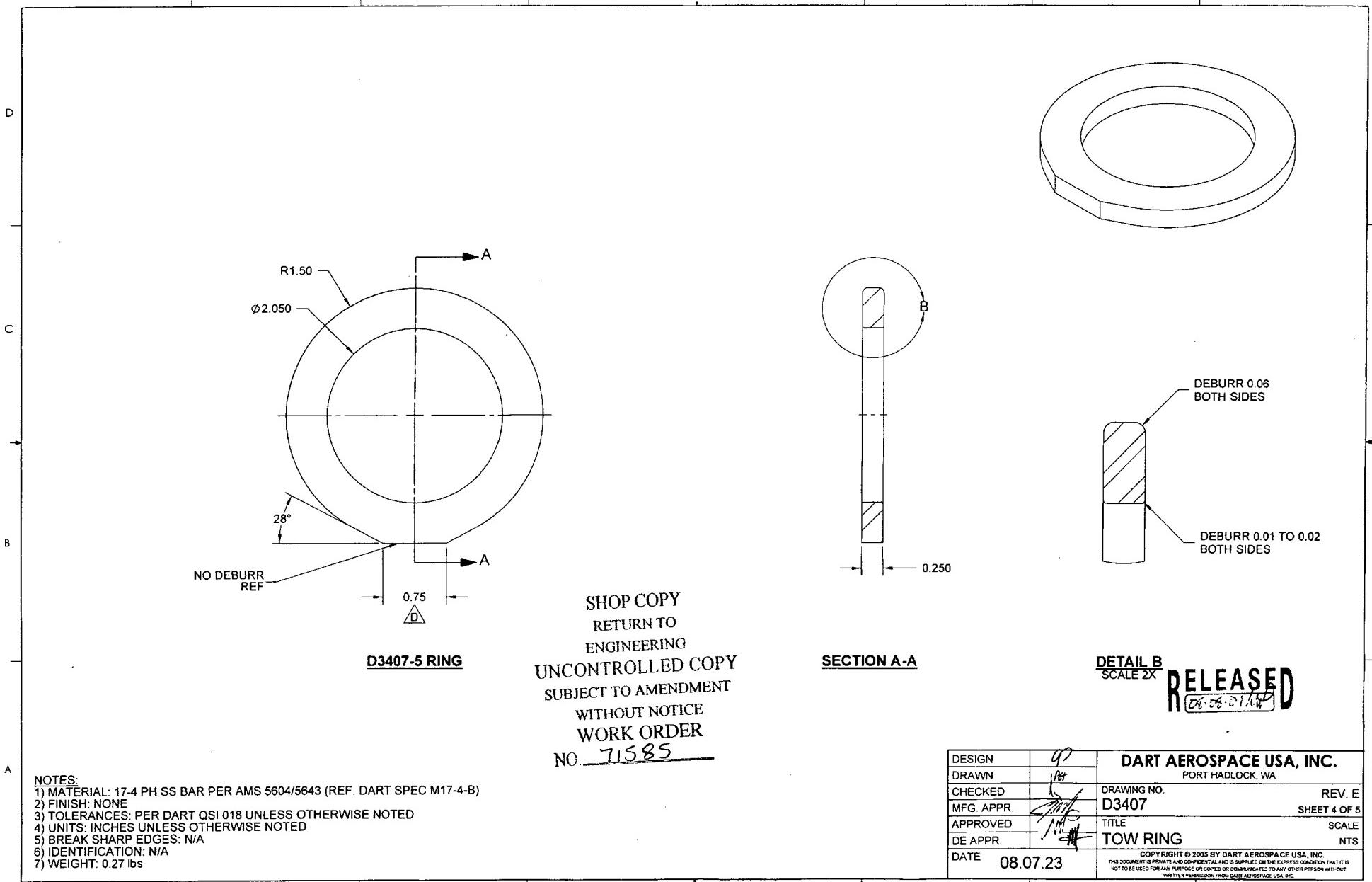
DESIGN	9P	DART AEROSPACE USA, INC.
DRAWN	AS	PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. E
MFG. APPR.		D3407 SHEET 2 OF 5
APPROVED		TITLE SCALE
DE APPR.		TOW RING NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

